

# split Work Order ID 57544-2

April 8, 2010 9:06:34 AM



Page 1

Item ID: D2012-105

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 4/08/10

Start Qty: 10.00



Cust Item ID:

Required Date: 4/13/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2012-105

Rev D1

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch to length as per Dwg D2012-105 & template D2012-105T1

=> m-k

w/04/28

(4X)

=> m-k

w/06/21

(6X)

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr

=> m-k

w/04/29

(4X)

=> m-k

w/06/21

(6X)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Solo 6/21

(4X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Accept



Setup Start

**Stop**

Start Qty: 10.00

**Req'd Qty: 10.00**

Cust Item ID:

**Customer:**

**Reference:**

**Process Plan:**

Date:

**Tooling:**

Date:

Run Start

**QC:**

Date:

SPC (Y/N):

Date:

**Stop**

Insp.  
Stamp

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Powdercoat

## Memo

0.00

### Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140

### QC3- Inspect Part Finish

0.00

QC

## Memo

0.00

### Quality Control

150

Identify as per dwg & Stock Location:

0.00

### Packaging

## Memo

0.00

### Packaging

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57544**

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Item ID: D2012-105

Accept



Setup Start



Revision ID:

Item Name: Arm

Stop



Start Date: 4/08/10

Start Qty: 10.00



Required Date: 4/13/10

Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28 JG  
C210/6/25



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April 8, 2010 9:06:33 AM

Page 1

Work Order ID: 57544

Parent Item: D2012-105

Parent Item Name: Arm


Comments: IPP Rev: ☐ 02.04.03 ☐ Added Inspect level 3 ☐ NG ☐

Start Date: 4/08/10

Required Date: 4/13/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	29.6240	27.6358			
												
304 RD Tube .500 x .035W												

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT017

29.624

112187

4.75

112800

24.874

(4x) M114356 ✓

(6x) M114356

\_\_\_\_\_ m-k  
 \_\_\_\_\_ 10/04/28  
 11.0543  
 16.58148 m-k  
 10/06/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

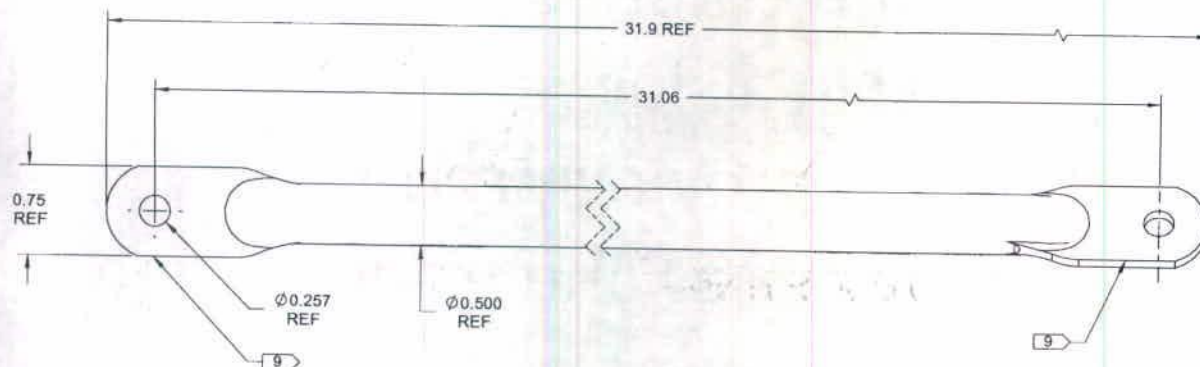
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

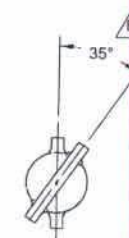
**NOTE:** Date & initial all entries



W/O 57544



**D2012-105 ARM**



- NOTES:
- 1) MATERIAL: AISI 304/316 SS TUBE  $\phi 0.500 \times 0.035$  WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
  - 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2012-105" USING REMOVABLE TAG
  - 7) WEIGHT: 0.47 lbs
  - 8) MAKE PER TEMPLATE DT8116
  - 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

**RELEASED**  
01/16/2014

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CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	JP	D2012-105	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	ARM	NTS
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## Lean Is...

- “LEAN IS – from an operations perspective... a system that cuts costs & inventories rapidly to free cash, which is critical in a slow economy. It also supports growth by improving productivity and quality, reducing lead times and freeing huge amounts of resources.
- Lean aims at reducing (if not eliminating) none value added activities in business processes.
- It's not a project.